

Ship Oct 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:18:51 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 34821	
Estimate Number : 12492	
P.O. Number : N/A	Part Number : D35143
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW D3514
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : SMALL /MED FAB	Drawing Revision : N/A A 10/09/24 E
Previous Run : 33307	Material : N/A
Written By : _____	Due Date : 10/12/2007 Qty: 5 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 06-07-26 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.4812 sf(s)/Unit Total : 2.4061 sf(s)  
6061-T6 .040 Sheet  
(M6061T6S040)  
Batch: m102723 HB 07-10-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3514  
Dwg Rev: A HB 07-10-2  
Prog Rev: A

(S)

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary HB 07-10-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-10-2

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK En 07/10/02 (S)

counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Countersink as per Dwg D3514

mf

07-10-10 (S)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 09/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/21/2007 1:18:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34821

Part Number: D35143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Can't  
07/10/10 (5)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB 07/10/10 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/10 (5)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 07/10/10

(5x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-11 (5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GA MF 07-10-11 (5)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
07/10/10

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

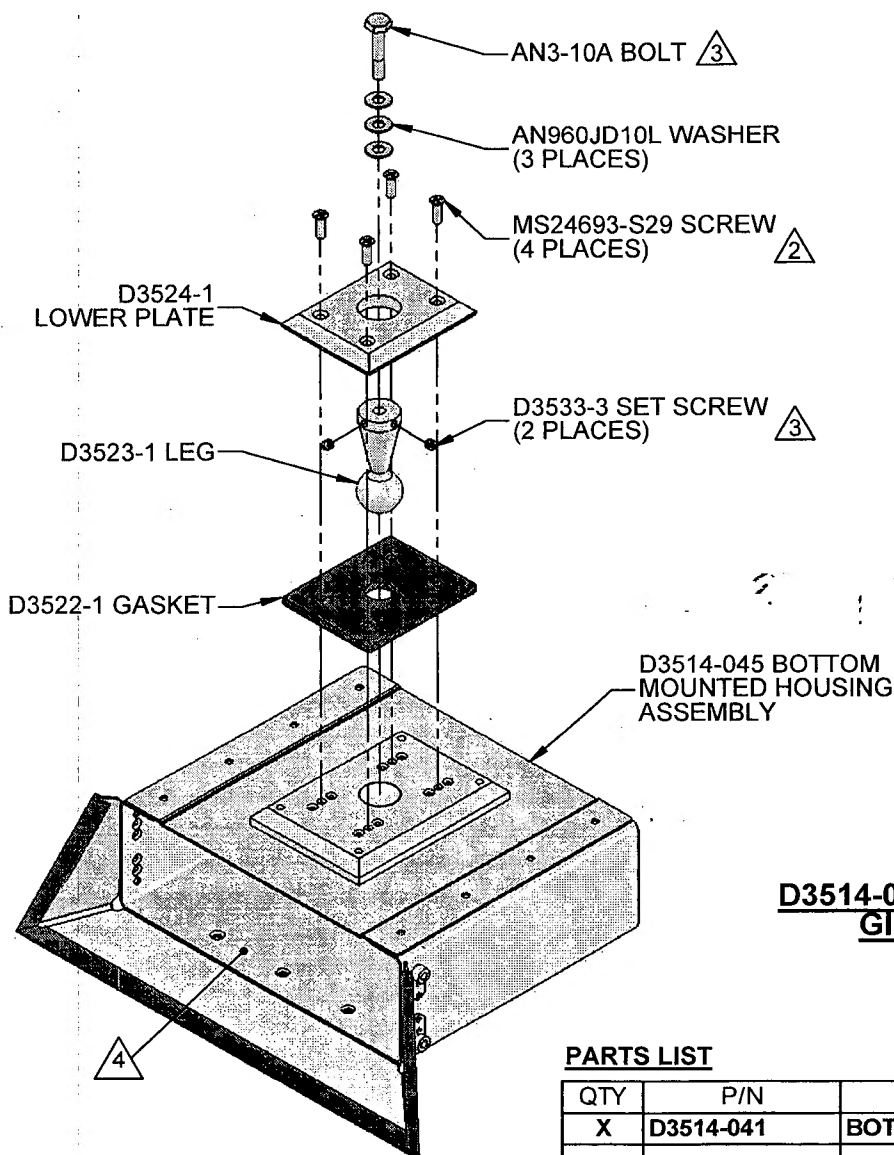
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



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07.08.03

**D3514-041 BOTTOM MOUNTED  
GIMBAL ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

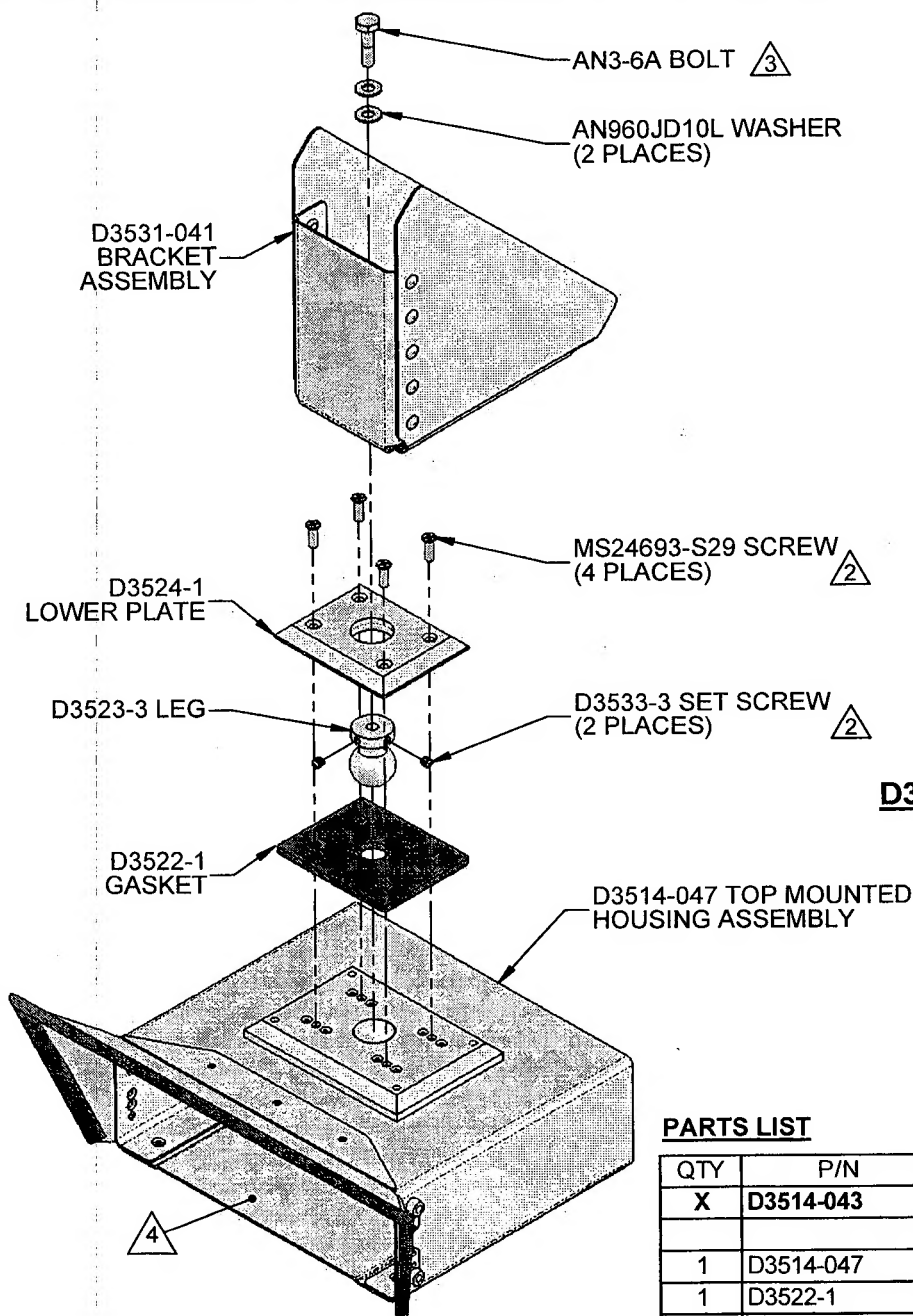
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3514</b>
DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 2 OF 9 SCALE 1:3



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07.08.03

**D3514-043 TOP MOUNTED  
GIMBAL ASSEMBLY**

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NO. \_\_\_\_\_

**PARTS LIST**

QTY	P/N	DESCRIPTION
<b>X</b>	<b>D3514-043</b>	<b>TOP MOUNTED GIMBAL ASSEMBLY</b>
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

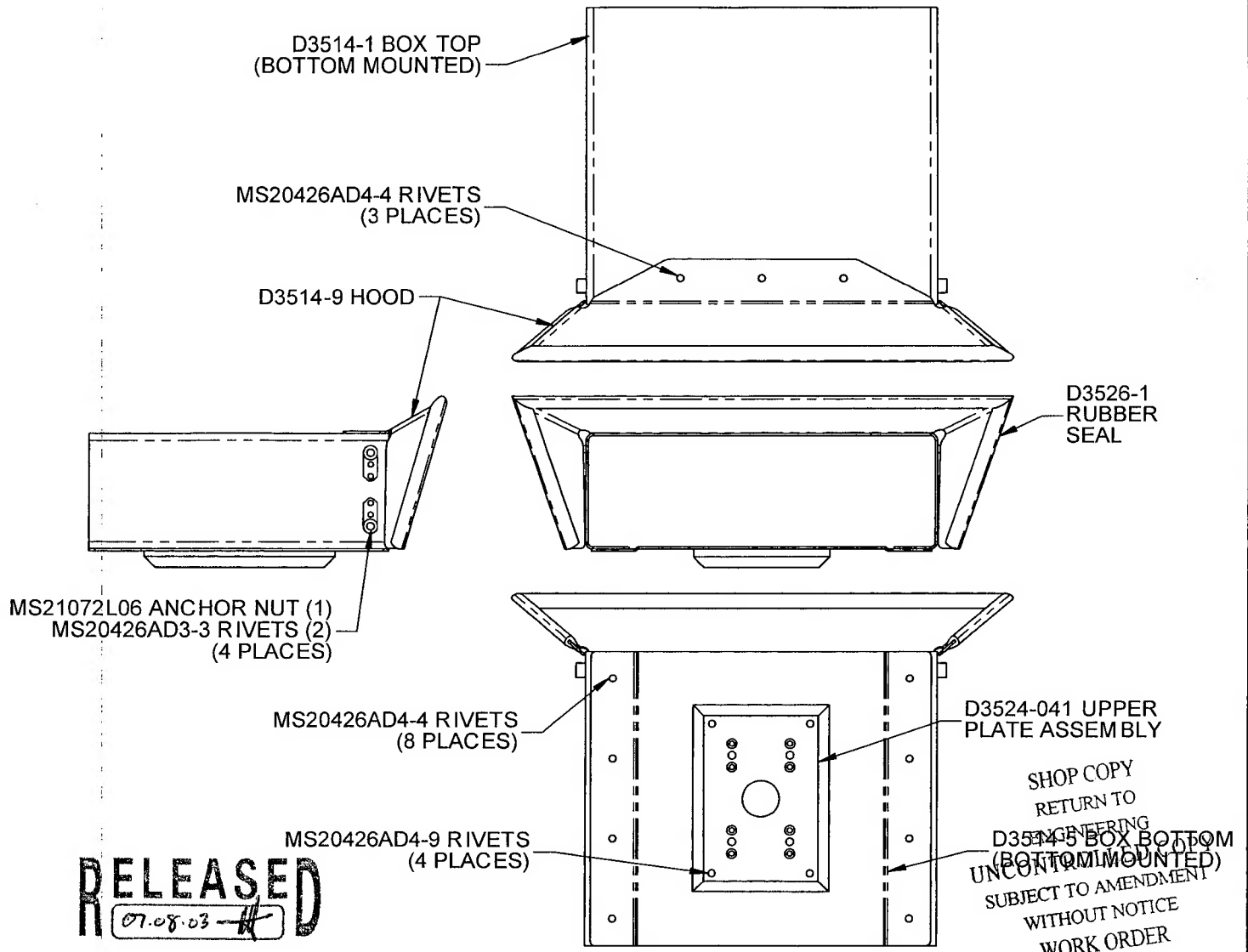
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



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D3514-5 BOX BOTTOM  
(BOTTOM MOUNTED)  
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WORK ORDER  
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**D3514-045 BOTTOM MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

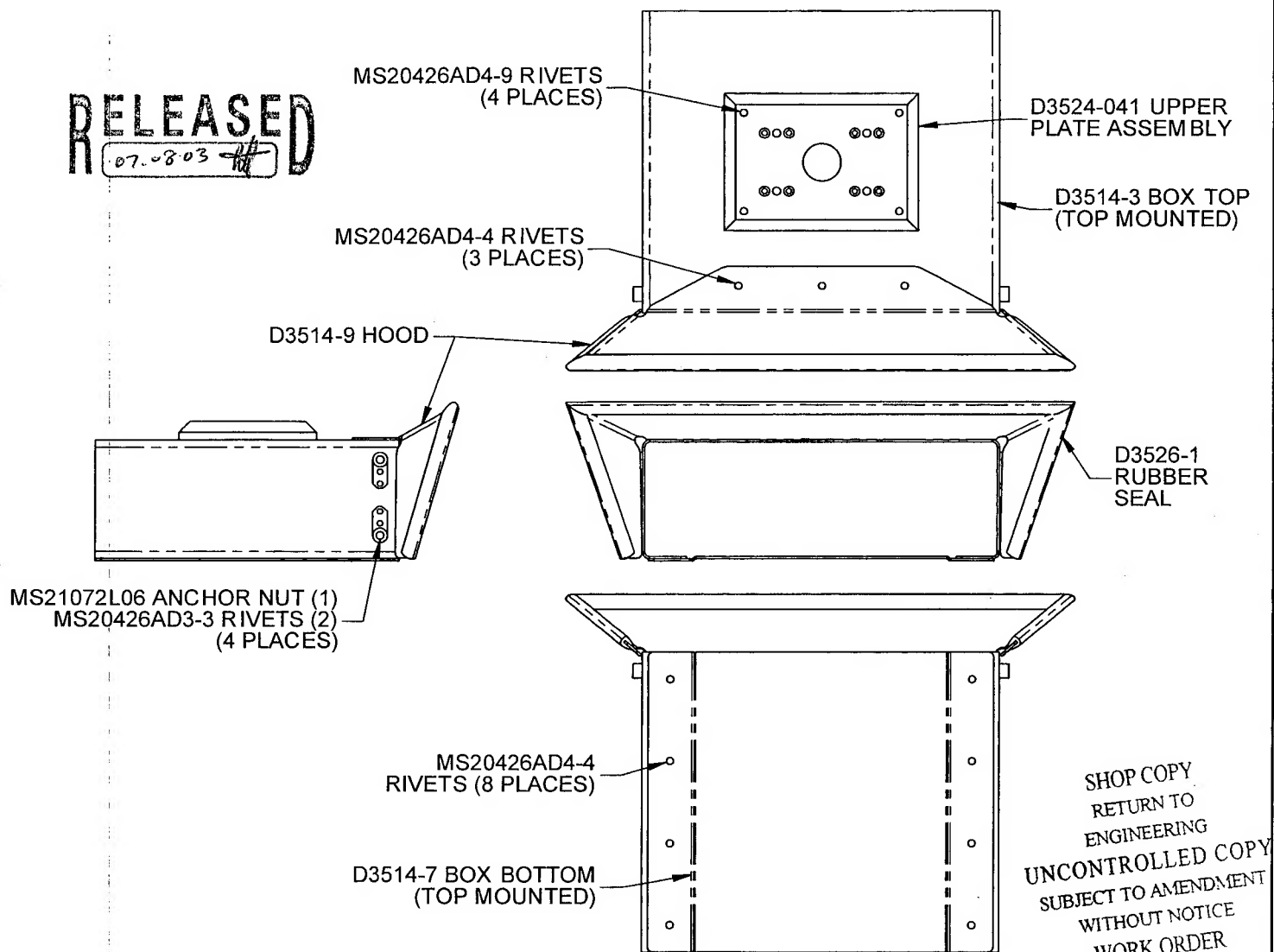
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**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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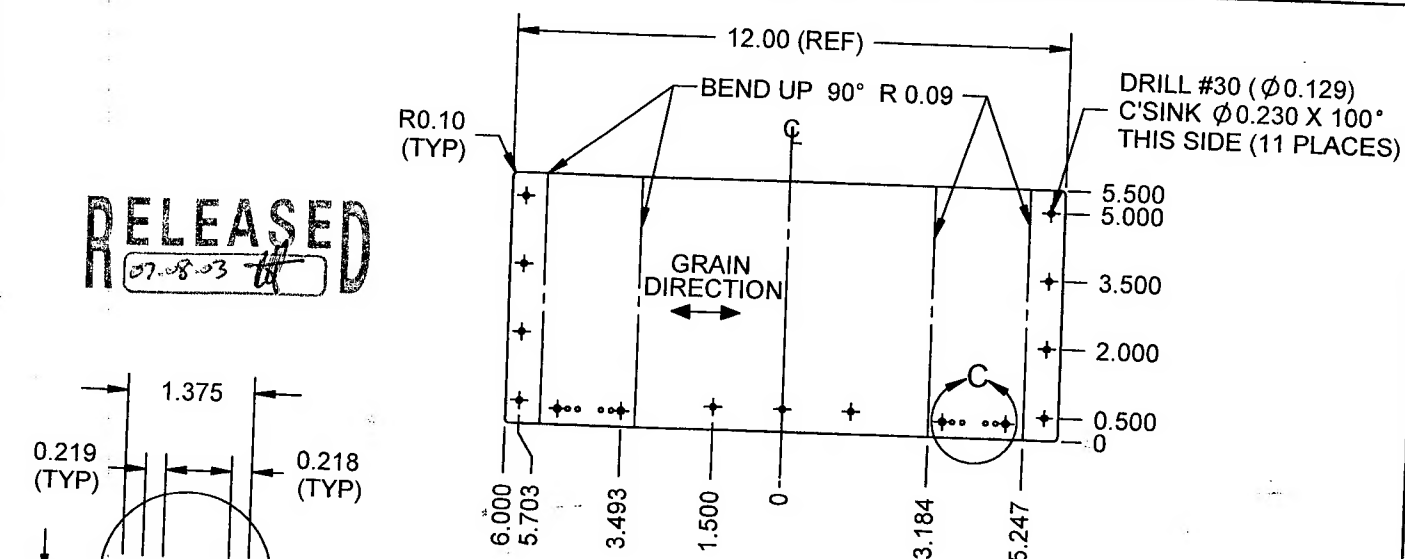
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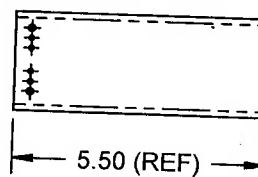
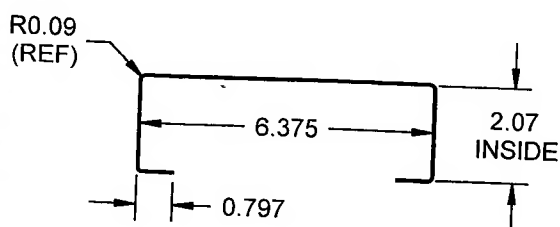
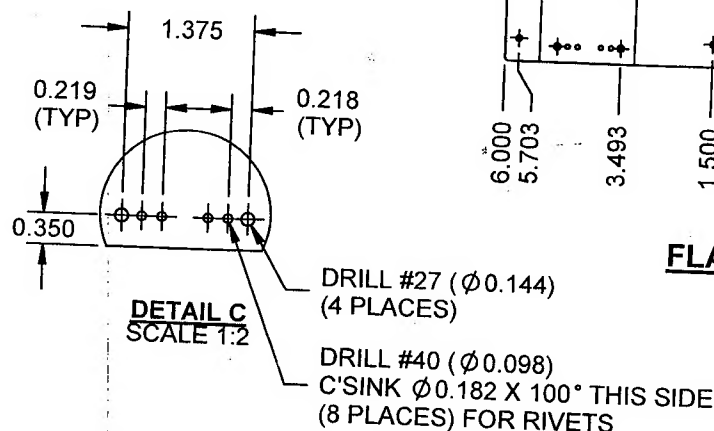
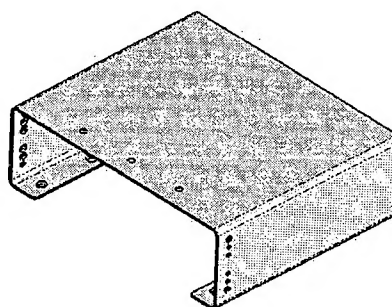


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DATE 07.06.18	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 5 OF 9 SCALE 1:4

RELEASED  
07-08-03 [Signature]



**D3514-1F  
FLAT PATTERN**



**D3514-1 BOX TOP (BOTTOM MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI M6061T6S.040
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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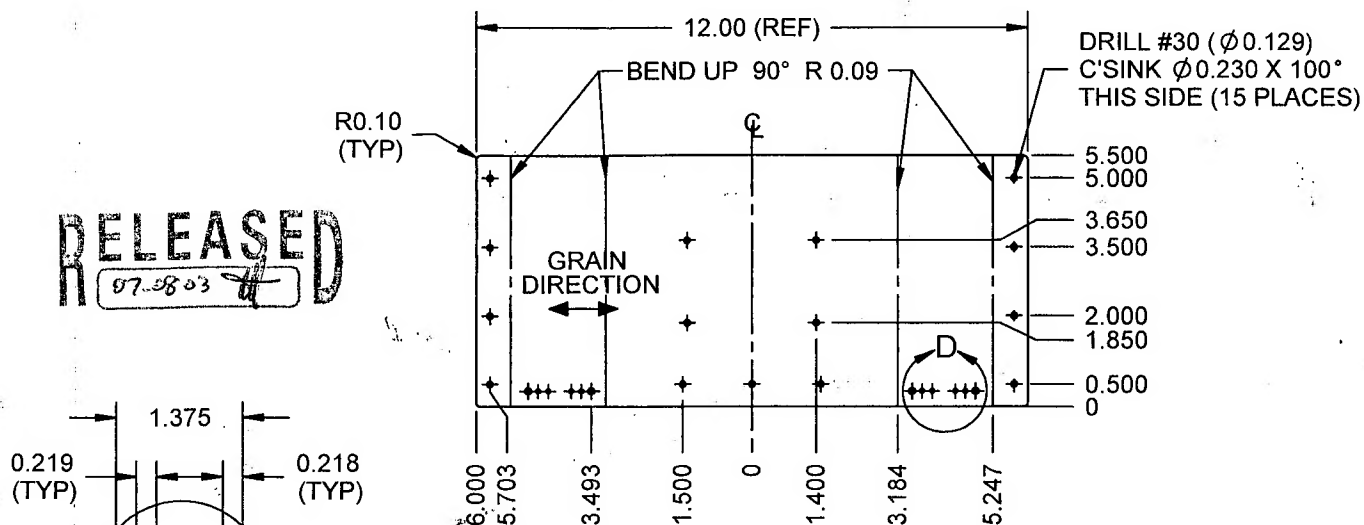
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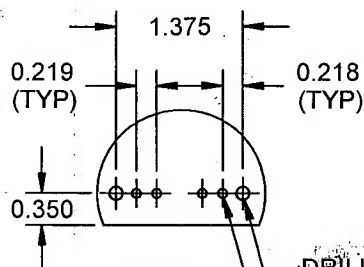


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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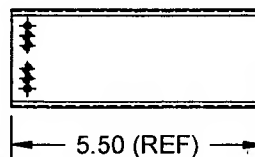
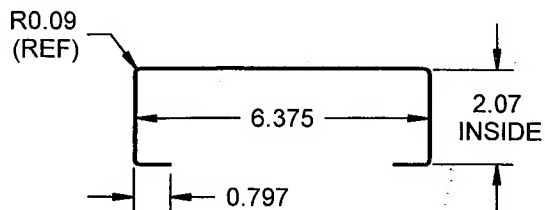
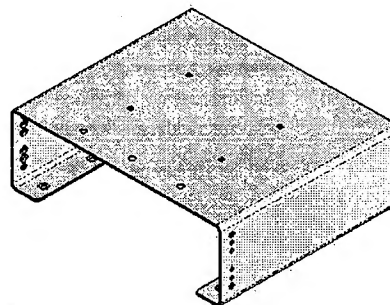
**D3514-3F  
FLAT PATTERN**



**DETAIL D  
SCALE 1:2**

DRILL #27 (Ø0.144)  
(4 PLACES)

DRILL #40 (Ø0.098)  
C'SINK Ø0.182 X 100° THIS SIDE  
(8 PLACES) FOR RIVETS



**D3514-3 BOX TOP (TOP MOUNTED)**

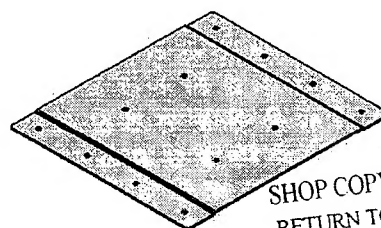
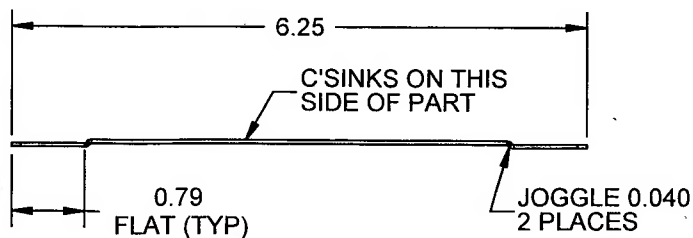
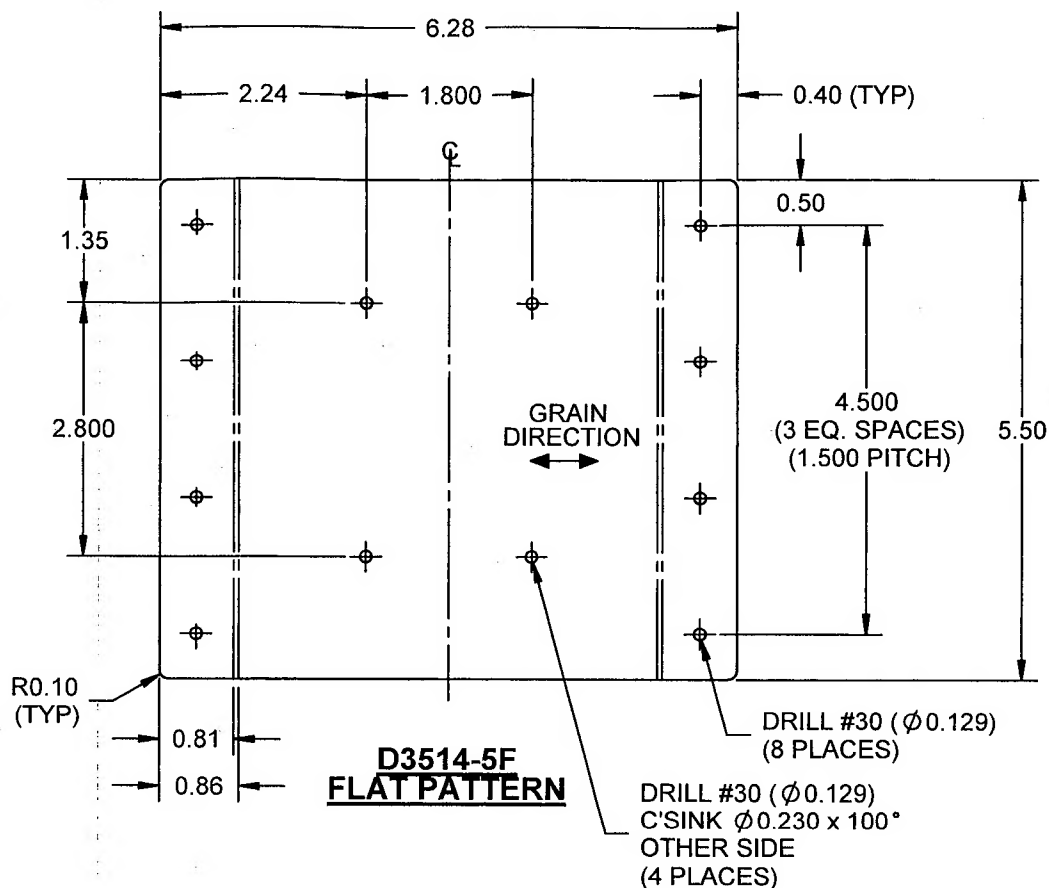
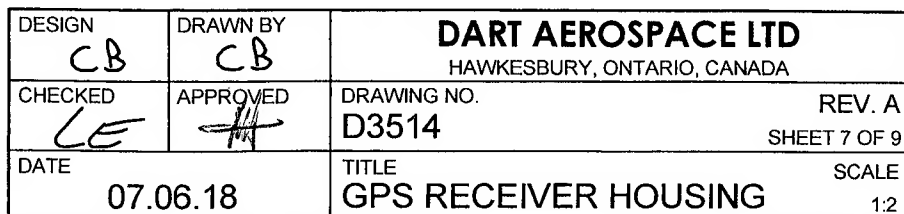
**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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07-08-03

### **D3514-5 BOX BOTTOM (BOTTOM MOUNTED)**

NOTES:

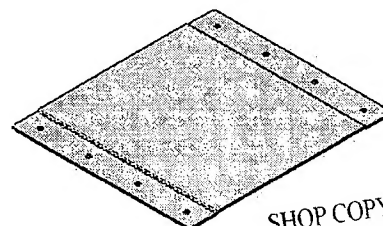
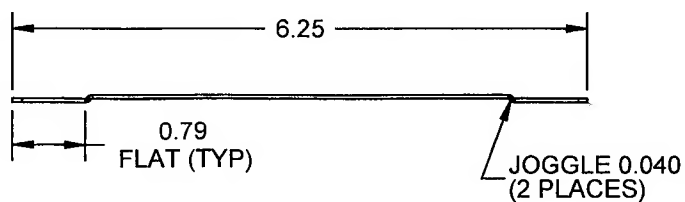
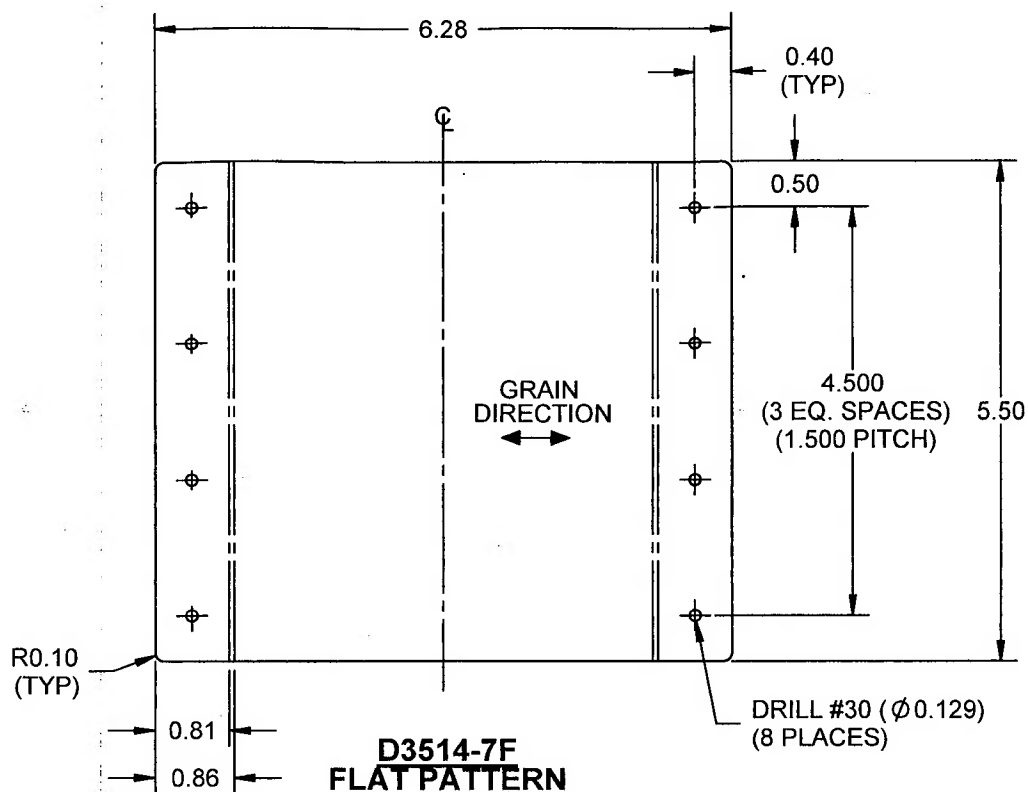
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
5) BREAK ALL SHARP CORNERS TO 0.010 MAX  
6) PART IS SYMMETRIC ABOUT  $\phi$   
7) C'SINK ABOVE JOGGLE

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3514</b>	REV. A SHEET 8 OF 9
DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:2



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**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

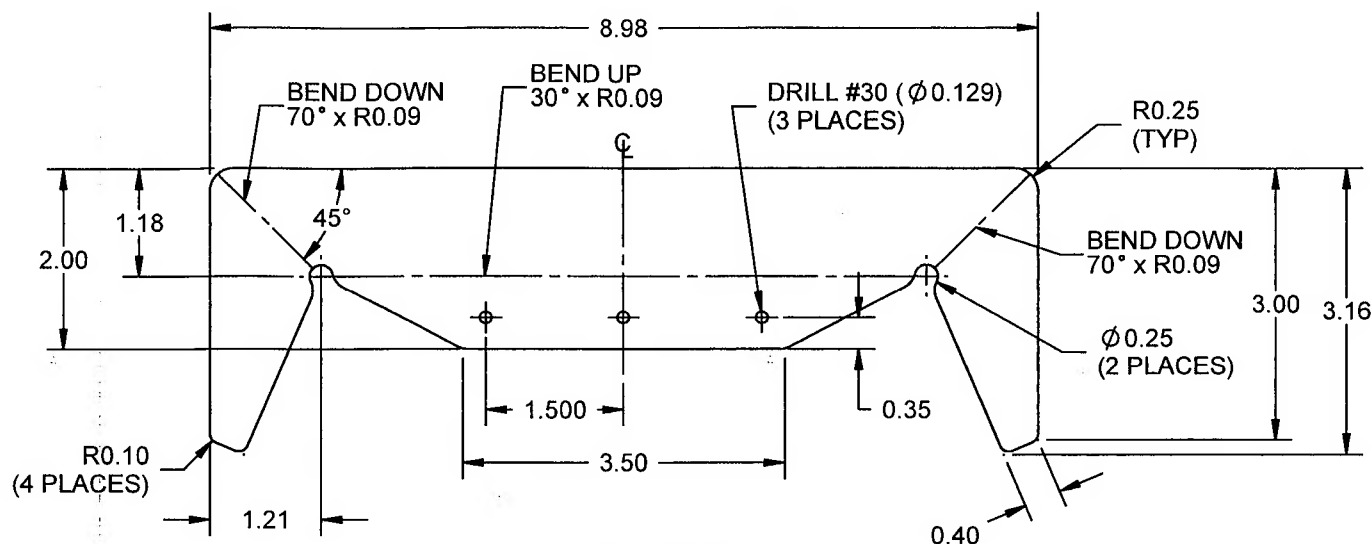
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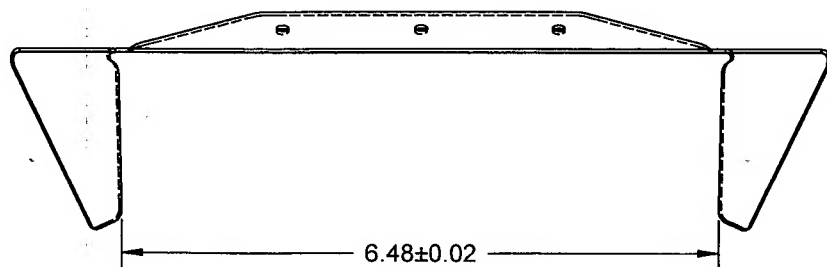
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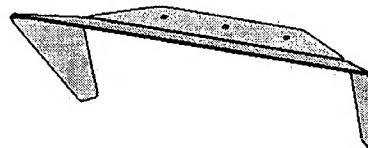
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-9F  
FLAT PATTERN**



**FRONT VIEW**



**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

**RELEASED**  
07.08.03 [Signature]

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
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DART AEROSPACE LTD		Work Order: 34821
Description: GPS RECEIVER HOUSING		Part Number: D3514-3
Inspection Dwg: D3514 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .144	+ .005 - .001	.148	X			
Ø .129	+ .005 - .001	.130	X			
Ø .098	+ .004 - .001	.100	X			
5.500	+/- .010	5.500	X			
5.000	+/- .010	5.000	X			
3.650	+/- .010	3.650	X			
3.500	+/- .010	3.500	X			
2.000	+/- .010	2.000	X			
1.850	+/- .010	1.850	X			
.500	+/- .010	.500	X			
12.00	+/- .030	12.00	X			
6.000	+/- .010	6.000	X			
5.703	+/- .010	5.703	X			
3.493	+/- .010	3.493	X			
1.500	+/- .010	1.500	X			
1.400	+/- .010	1.400	X			
3.184	+/- .010	BEND	X			
5.247	+/- .010	BEND	X			
1.375	+/- .010	1.375	X			
.218	+/- .010	.218	X			
.219	+/- .010	.219	X			
.350	+/- .010	.350	X			

Measured by: RB	Audited by: 	Prototype Approval:
Date: 07-10-2	Date: 07/10/02	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	